

5114

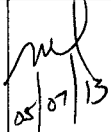

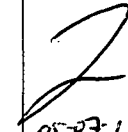
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22636
<b>Description:</b> Side (LH)	<b>Part Number:</b>	D3254-041
<b>Dwg:</b> D3254 Rev. A	<b>Qty:</b>	10
REF. ICA-D3254-041 REV. 0 PAGE 19 & 21		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	FA	05.03.09	10
2	PG	Issue P/O: 2007692 Fabricate D3254-1 as per Dwg D3254 Possible Supplier: Industrial Laser <b>Material release note is required</b>	KL	05.03.10	10
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	CL	05/06/08	10
4	QC6	Inspect dimensions as per Dwg D3254	ml	05/02/13	10
5	GA	Deburr	ml	05/07/13	10
6	QC5	Inspect work to Step 5	J	05.08.02	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.08.03	10
8	QC3	Inspect Chemical Conversion Coat	J	05.08.11	10
9	GA	Assemble D3254-041 as per Dwg D3254 <b>Pick:</b> Qty Part Number Description Batch 2 D3248-1 Doubler 22636 1 D3254-1 Side (LH) 22636 18 MS20470AD4-5 Rivet M16163 <b>Identify as D3254-041</b>	SAD	05/08/12	10
10	QC5	Inspect work to Step 9	J	05.08.15	10
11	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05/08/16	10
12	QC3	Inspect Powder Coat	M	05/08/16	10
13	ST	Identify and Stock	DL	05/08/18	10
14	AC	Cost / part			
15	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3254-1 no longer made in-house	KJ/JLM	

RELEASED  
04/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/13	4	the dimention are good except 18 pls Holes. should be $\phi.128$ / was $\phi.121$ except 15 pls Holes. should be $\phi.098$ / was $\phi.090$		Re-do 18 pls Holes to $\phi.128$ Re-do 15 pls Holes to $\phi.098$ Smooth buffing	 05/07/13	 05-08-02		 05-07-13
		Some parts are dirty						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

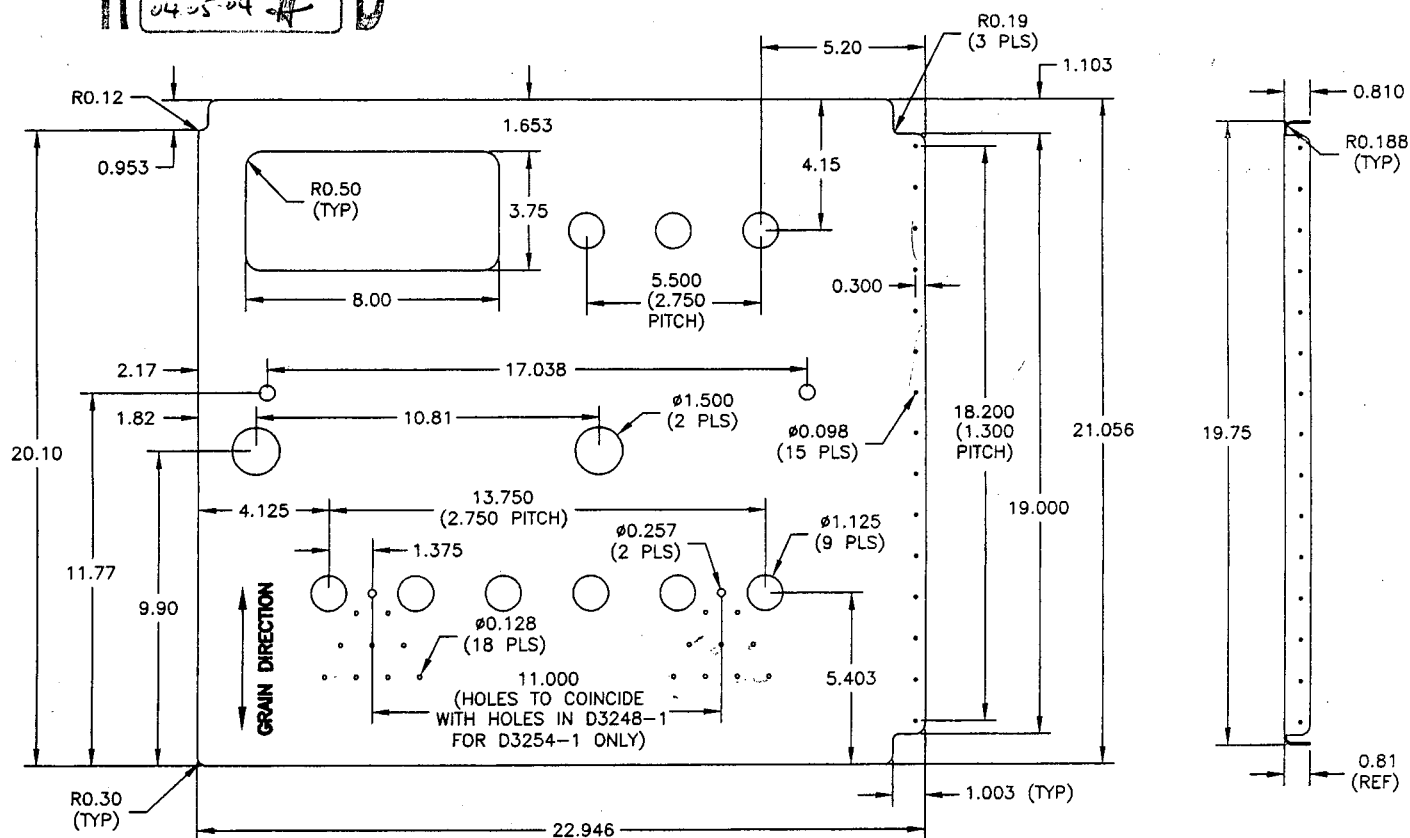
NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

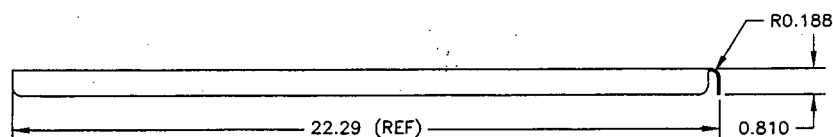


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3254	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

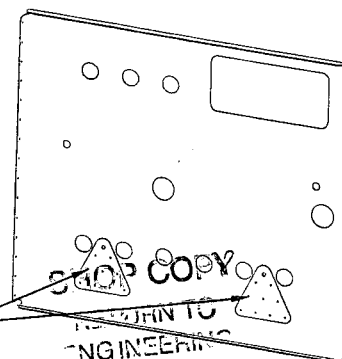
RELEASED



D3254-1/-2 FLAT PATTERN



**D3254-1 BEND DETAIL (SHOWN)**  
**D3254-2 OPPOSITE**



INSTALL D3248-1  
USING MS20470A4-5  
RIVETS

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

CONFIDENTIAL **D3254-041**  
NOT TO  
WITHHOLD  
WORK  
NO. 226.36

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# PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS  
4700 COLORADO AVENUE  
SEATTLE WA

98124

ALASKAN

T86002 4330

## CERTIFIED TEST REPORT

PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS  
P.O. BOX 3546  
SEATTLE WA

98124

2

CUSTOMER PURCHASE ORDER NO. & ITEM <b>16497</b>				PECHINEY ORDER NO. <b>052-880417</b>	
ALLOY <b>5052</b>	CLAD. <b>00</b>	TEMPER <b>H32</b>	GAUGE <b>.06300</b>	WIDTH <b>48.000</b>	LENGTH <b>.000</b>
ITEM ORDERED <b>RAVENSWOOD DISTRIBUTOR SPEC COIL NON HT MILL</b>					
CUSTOMER SPECIFICATION <b>AMS-QQ-A-250/8</b>					
PART NUMBER			B/L NUMBER <b>T86000</b>	DATE SHIPPED <b>04-09-03</b>	
WEIGHT SHIPPED <b>13,345</b>		NO. OF PIECES <b>1</b>		GOVT. CONTRACT NO.	

**CERTIFICATION**  
"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."  
**PECHINEY ROLLED PRODUCTS**  
RAVENSWOOD, WV 26164  
*Mark E. Parsons*  
MARK E. PARSONS-LABORATORY SUPERVISOR

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		MIN	MAX									
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.											
449461			ACTUAL CHEMICAL COMPOSITION																
			SI=0.10 FE=0.27 CU=0.07 MN=0.05 MG= 2.4 CR=0.18 ZN=0.02 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																
IC	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
		ALUMINUM REMAINDER																	

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ALASKAN COPPER & BRASS  
4700 COLORADO AVENUE  
SEATTLE WA

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## CERTIFIED TEST REPORT

PECHINEY ROLLED PRODUCTS

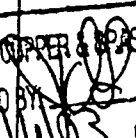
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ALASKAN T86002 4330

1

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			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.										
449461	L	2	33.8	33.8	27.6	27.6	9.3	10.9	.0	.0								
ALSO CONFORMS TO ASTM B209																		
<div>ALASKAN COPPER &amp; BRASS CO APPROVED BY:  DATE: 4/14/03 P.O.: 1497</div>																		
ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
	SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																		